

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002659**Date Inspected:** 23-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

The Quality Assurance Inspector performed a survey of the Chevron Bracing Plates to Floor Beam Bottom Flanges misalignment between the Chevron Bracing and the Vertical Stiffener. The Quality Assurance Inspector measured the misalignment as follows:

SSD17A-PP021-132: 1.5 mm

SSD17A-PP021-131: 9 mm

SSD17-PP021-006: 3 mm

SSD17-PP021-005: 3 mm

SSD16A-PP020-132: 4.5 mm

SSD16A-PP020-131: 17.5 mm

SSD16-PP020-006: 6 mm

SSD16-PP020-005: 1.5 mm

SSD19-PP023-136: 4.5 mm

SSD19-PP023-137: 6.5 mm

SSD19-PP023-136: 7 mm

SSD19-PP023-136: 1.5 mm

Below are two digital photographs illustrating how the misalignment was measured. The Quality Assurance Inspector was informed the maximum allowable misalignment was 1.4 millimeters. The Quality Assurance Inspector generated an incident report pertaining to the discrepancy.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

As stated in the contents of the above report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (916) 227-5719, who represents the Office of Structural Materials for your project.

Inspected By:	Bertlesman,Greg	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
